

PN - JP11268574 A 19991005

PD - 1999-10-05

PR - JP19980074168 19980323

OPD - 1998-03-23

TI - ASH TRAY COVER AND ASH TRAY

AB - PROBLEM TO BE SOLVED: To mold an ash tray and an ash tray cover by using poly phenylene sulfide(PPS) recently increasing a production amount and lowering its price to perform surface decoration being secondary processing without applying primer processing after molding thereof.

SOLUTION: The cover base material 4 of an ash tray cover 1 is molded by using PPS having excellent flame retardance, and molding is effected such that the surface thereof is covered with a surface material 5 of ABS resin having excellent painting properties and printing properties, whereby a pattern and a design for decoration are directly printed or painted without applying primer treatment. In this case, since, after the surface material 5 is molded by using ABS resin, molding is effected by two-time injection molding that the cover base material 4 is molded by using PPS, the two materials are firmly thermally welded. Further, since molding shrinkage of a cover base material 4 occurring thereafter and a shrinkage factor occasioned by cooling of the surface material 5 pressurized by the mold are low, the surface material 5 is prevented from peeling from the surface of the cover base material 4 and the occurrence of a defective product is decreased.

IN - YAMADA TOMOHIRO; TAKENAKA TOMONARI; ASAHI HIROMITSU

PA - TRINITY IND CORP

IC - B60N3/08; A24F19/00; B29C45/16; B29K55/02; B29K81/00; B29L22/00

TI - Ashtray lid structure in cars, electric trains, aircraft - includes lid base and heat welded decorative portion molded separately using different resins

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PA - (TRIN-N) TRINITY IND CORP

IC - A24F19/00 ;B29C45/16 ;B29K55/02 ;B29K81/00 ;B29L22/00 ;B60N3/08

AB - JP11268574 NOVELTY - An ashtray lid (1) includes lid base (4) molded by polyphenylene sulfide (PPS) and decorative surface layer (5) separately molded by acrylonitrile butadiene styrene (ABS) resin. Heat welding of the base and decorative layer is performed. DETAILED DESCRIPTION - An INDEPENDENT CLAIM is also included for an ashtray which has a decorative surface portion molded by ABS resin and a tray receptacle separately molded by PPS resin.

- USE - For disposal of cigarette ends in cars, electric trains and aircraft.

- ADVANTAGE - PPS resin is excellent in heat resistance and ABS resin is excellent in coating or printing property, hence surface decoration is performed without priming after completion of molding. Decorative surface portion is first molded by ABS resin, then a lid base is molded by PPS; hence thermal expansion is restrained within the mold and amount of contraction by cooling is small. Compared to ABS resin, the co-efficient of linear expansion of PPS is small. Therefore a decorative surface layer does not peel from base. DESCRIPTION OF DRAWING - The figure shows the ashtray lid structure. (1) Ashtray lid; (4) Lid base; (5) Decorative surface layer.

- (Dwg.1/5)

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IN - YAMADA TOMOHIRO;TAKENAKA TOMONARI;ASAI HIROMITSU  
PA - TRINITY IND CORP  
TI - ASH TRAY COVER AND ASHTRAY  
AB - PROBLEM TO BE SOLVED: To mold an ashtray and an ashtray cover by using poly phenylene sulfide(PPS) recently increasing a production amount and lowering its price to perform surface decoration being secondary processing without applying primer processing after molding thereof.  
- SOLUTION: The cover base material 4 of an ashtray cover 1 is molded by using PPS having excellent flame retardance, and molding is effected such that the surface thereof is covered with a surface material 5 of ABS resin having excellent painting properties and printing properties, whereby a pattern and a design for decoration are directly printed or painted without applying primer treatment. In this case, since, after the surface material 5 is molded by using ABS resin, molding is effected by two-time injection molding that the cover base material 4 is molded by using PPS, the two materials are firmly thermally welded. Further, since molding shrinkage of a cover base material 4 occurring thereafter and a shrinkage factor occasioned by cooling of the surface material 5 pressurized by the mold are low, the surface material 5 is prevented from peeling from the surface of the cover base material 4 and the occurrence of a defective product is decreased.  
SI - B29K55/02 ;B29K81/00 ;B29L22/00  
I - B60N3/08 ;A24F19/00 ;B29C45/16

く、また、PPSはABS樹脂に比して線膨張係数が小さいので、双方の収縮量の差はほとんどなく、したがって、表面材が蓋基材の表面から剥離することもなく、製品不良が少ないという効果もある。

【図面の簡単な説明】

【図1】 本発明に係る灰皿蓋を示す図。

【図2】 (a)～(d)はその成形工程図。

【図3】 本発明に係る灰皿を示す図。

【図4】 その成形装置を示す説明図。

【図5】 本発明に係る他の灰皿を示す図。

【符号の説明】

1 … 灰皿蓋

3 … 灰皿容器

4 … 蓋基材

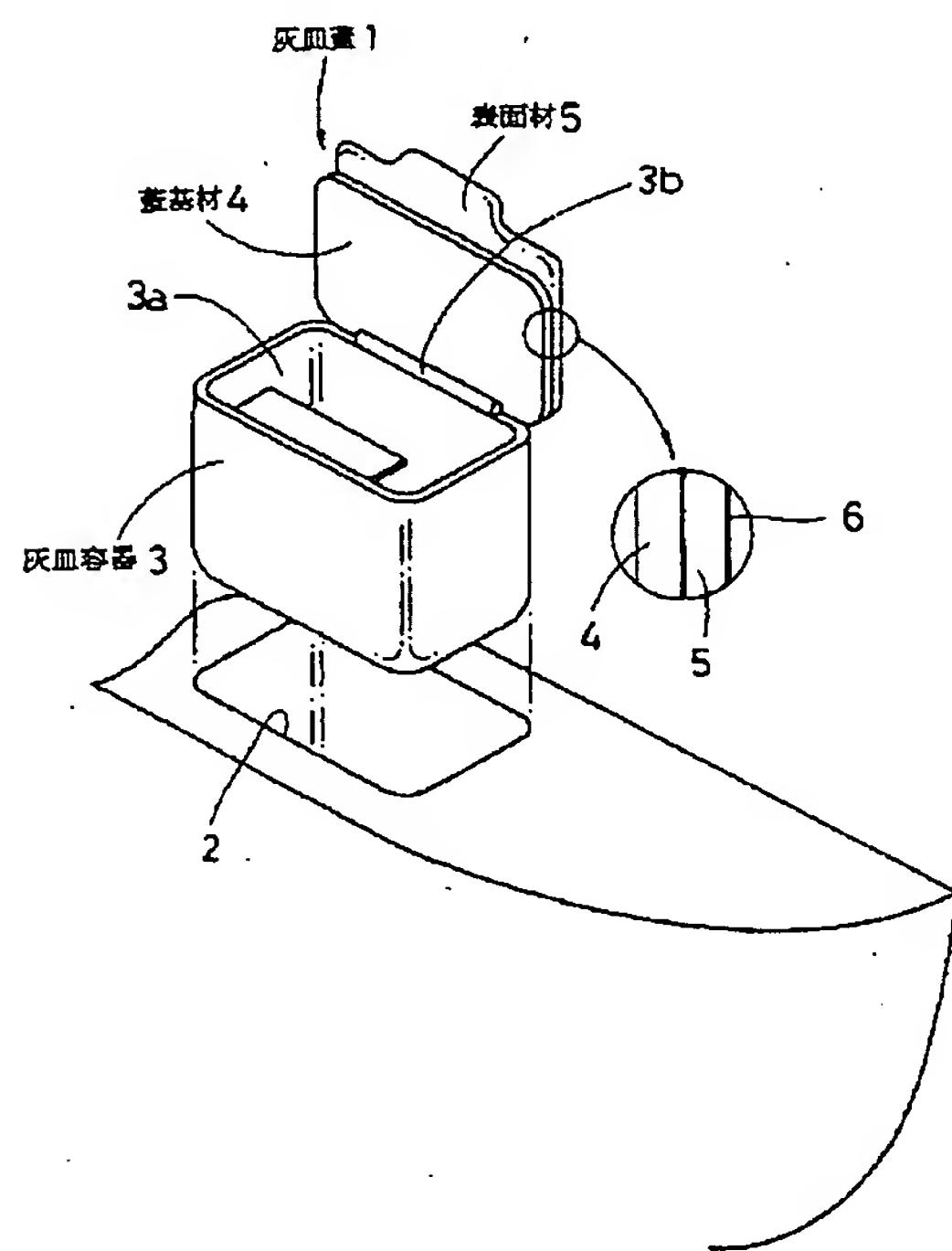
5, 34, 44 … 表面材

30, 40 … 灰皿

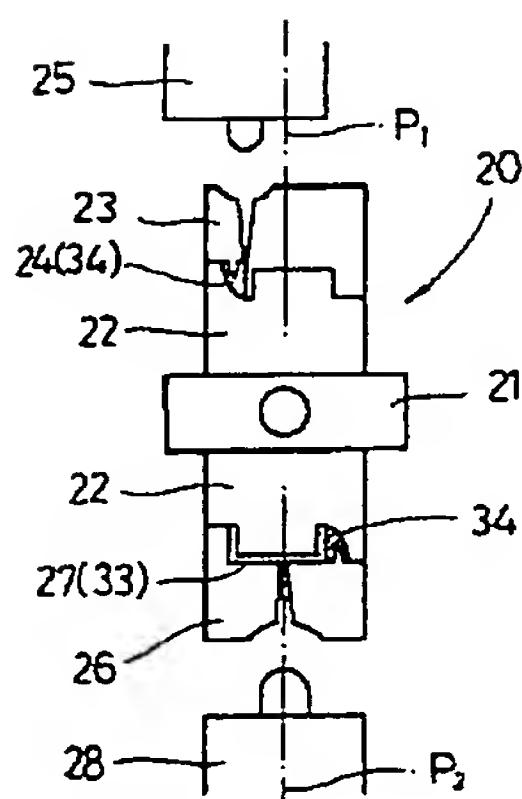
33 … トレー形容器

43 … ポケット形容器

【図1】



【図4】



【図2】

